

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012570**Date Inspected:** 22-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** You Qi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY 10

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint # 4A according to the critical weld repair report #T-CWR-543 located on North Tower Lift-4 A/E corner NSTL4-3B/L. Welder is identified as 066236. ZPMC Quality Control (QC) Inspector is identified as Liu Zhong An. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – Repair.

Sub-Merged Arc Welding (SAW):

Weld joint # 9A located on South Tower Lift-5 A/B corner SSD1 – TL5 – 1B – F. Welder is identified as 050295. ZPMC Quality Control (QC) Inspector is identified as Jiang La Mei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – C – U2b – S.

BAY 11

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW):

Weld joint # 16B/39B located on East Tower Lift-5 C/D corner ESD1 – TL5 – 2B/F. Welder is identified as 066361. ZPMC Quality Control (QC) Inspector is identified as Li Lin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – C – U2. (See attached photo)

Sub-Merged Arc Welding (SAW):

Weld joint # 4-1B located on Strut angle connection Plate ED1 – SA4 – 68 – 123M. Welder is identified as 042195. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – Tc – U5 – S – 1.

Weld joint # 2-6B located on Strut Plate ND1 – STSA4 – 10 – 119M. Welder is identified as 040699. ZPMC Quality Control (QC) Inspector is identified as Liu Pao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4221 – B – U3c – S – 1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Clifford, William

QA Reviewer